



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 179527



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 6/30/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/30/18	6/30/18	0.00	0.00	Start Up Large Fab-4		SL4
110	Large Fab	1 pcs	6/30/18	6/30/18	0.00	0.99	Large Fab 2		SL4
120	QC	1 pcs	6/30/18	6/30/18	0.00	0.00	QC9		21 2018-06-21
130	QC	1 pcs	6/30/18	6/30/18	0.00	0.00	QC5		21 2018-06-21
140	HandFinish	1 pcs	6/30/18	6/30/18	0.00	0.18	HandFinish1		BEB 06-28
150	QC	1 pcs	6/30/18	6/30/18	0.00	0.00	QC7-2		38
180	Large Fab	1 pcs	6/30/18	6/30/18	0.00	0.99	Large Fab 2		9-89
190	QC	1 pcs	6/30/18	6/30/18	0.00	0.00	QC10		SL
200	QC	1 pcs	6/30/18	6/30/18	0.00	0.00	QC5		SL
210	HandFinish	1 pcs	6/30/18	6/30/18	0.00	0.18	HandFinish1		SA 18-07-04
220	Powdercoat	1 pcs	6/30/18	6/30/18	0.00	0.29	Powdercoat1		BR 18-7-10
230	HandFinish	1 pcs	6/30/18	6/30/18	0.00	0.18	HandFinish3		BEB 18-07-11
240	QC	1 pcs	6/30/18	6/30/18	0.00	0.00	QC3		38
250	Packaging	1 pcs	6/30/18	6/30/18	0.00	0.00	Packaging1-3		016 28
260	QC	1 pcs	6/30/18	6/30/18	0.00	0.00	QC4		9-89
270	Packaging	1 pcs	6/30/18	6/30/18	0.00	0.00	Packaging3-1		28
275	DC	1 pcs	6/30/18	6/30/18	0.00	0.00	DC		9-89
280	QC21-FG	1 Ea	6/30/18	6/30/18	0.00	0.00	QC21		21 JUL 19 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 1/2" x 1/8" 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 1/2" x 1/8" 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 8:30 OVEN TEMPERATURE: 350 FINISH TIME: 1:00

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

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Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	5082688
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	5069282
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	5082026
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	5084685
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab	5077435
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab	5079116
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	
D2618	Bushing	2 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	193	0
	D3219-1	2	115	0
	D3272-1	1	20	0
180-Large Fab	D3065-041	1	12	0
	D3066-1	2	204	0
	MS20600-AD4W4	16	3,836	0
250-Packaging	AN3-35A	2	240	0
	AN4-13A	8	917	0
	AN5-36A	2	234	0
	D2230-3	4	48	0
	D2618	2	280	0
	D2856-400-720	2	82	0
	D3235-1	2	178	0
	D3278-041	1	14	0
	MS21042L3	2	1,478	0
	MS21042L4	8	2,313	0
	MS21042L5	2	563	0
	NAS1149D0363J	4	1,945	0
	NAS1149D0463J	16	4,030	0
	NAS1149D0563J	4	1,939	0

Part Specifications	
Specifications could not be found.	

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Plex 6/20/18 8:17 AM dart.leroux.jason



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Container No: S082689



Part: D350-591-311

Job No: 179527

Serial No/Batch: S082689

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/20/18



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004318

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Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/30/18	0.00	0.00	Start Up Large Fab-4		
110	Large Fab	1 pcs		6/30/18	0.00	0.99	Large Fab 2		
120	QC	1 pcs		6/30/18	0.00	0.00	QC9		
130	QC	1 pcs		6/30/18	0.00	0.00	QC5		
140	HandFinish	1 pcs		6/30/18	0.00	0.18	HandFinish1		
150	QC	1 pcs		6/30/18	0.00	0.00	QC7-2		
180	Large Fab	1 pcs		6/30/18	0.00	0.99	Large Fab 2		
190	QC	1 pcs		6/30/18	0.00	0.00	QC10		
200	QC	1 pcs		6/30/18	0.00	0.00	QC5		
210	HandFinish	1 pcs		6/30/18	0.00	0.18	HandFinish1		
220	Powdercoat	1 pcs		6/30/18	0.00	0.29	Powdercoat1		
230	HandFinish	1 pcs		6/30/18	0.00	0.18	HandFinish3		
240	QC	1 pcs		6/30/18	0.00	0.00	QC3		
250	Packaging	1 pcs		6/30/18	0.00	0.00	Packaging1-3		
260	QC	1 pcs		6/30/18	0.00	0.00	QC4		
270	Packaging	1 pcs		6/30/18	0.00	0.00	Packaging3-1		
275	DC	1 pcs		6/30/18	0.00	0.00	DC		
280	QC21-FG	1 Ea		6/30/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 1-Grind End Plate flush 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 2:30 OVEN TEMPERATURE: 220 FINISH TIME: 4:00

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	2 Ea (2 ea)	90-Start up Operation	
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	5084685
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab	5077435
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab	5079116
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	5067897
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	5067892
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	5068656
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	5088979
D2618	Bushing	2 Ea (2 ea)	250-Packaging	5082278
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging	5079659
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	5069956
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	5076688
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	5078167
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	5062378
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	5058178
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	5085269
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	5062379
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	5068662

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	2	193	0
	D3219-1	2	115	0
	D3272-1	1	20	0
180-Large Fab	D3065-041	1	12	0
	D3066-1	2	204	0
	MS20600-AD4W4	16	3,836	0
250-Packaging	AN3-35A	2	240	0
	AN4-13A	8	917	0
	AN5-36A	2	234	0
	D2230-3	4	48	0
	D2618	2	280	0
	D2856-400-720	2	82	0
	D3235-1	2	178	0
	D3278-041	1	14	0
	MS21042L3	2	1,478	0
	MS21042L4	8	2,313	0
	MS21042L5	2	563	0
	NAS1149D0363J	4	1,945	0
	NAS1149D0463J	16	4,030	0
	NAS1149D0563J	4	1,939	0

Part Specifications

Specifications could not be found.



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004318	S090715	AN3-35A	Bolt	s067891	ST348	2
004318	S090714	AN4-13A	Bolt	s067892	ST344	8
004318	S090709	AN5-36A	Bolt	s068656	ST336	2
004318	S092846	D2230-3	Mounting Lug	s088979	ST521	2
004318	S092851	D2230-3	Mounting Lug	S088979	ST521	2
004318	S090789	D2618	Bushing	s082275	ST008	2
004318	S090790	D2856-400-720	Abrasion Strip 4" X 7.20"	s079659	ST418	2
004318	S090837	D3235-1	Mounting Lug	s069956	ST522	2
004318	S090836	D3278-041	Support Assembly	s076688	ST522	1
004318	S090695	MS21042L3	Nut	s078167	Cycle Retire	2
004318	S090678	MS21042L4	Nut	s062378	ST303	8
004318	S090677	MS21042L5	Nut	s058178	ST303	2
004318	S090675	NAS1149D0363J	Washer	s015269	ST263	4
004318	S090670	NAS1149D0463J	Washer	s062379	ST263	16
004318	S090658	NAS1149D0563J	Washer	s068662	ST263	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]